

Date: Tuesday, 12/4/2007 7:40:48 AM  
User: Chantal Lavoie








# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LITTER ASSEMBLY
<b>Job Number</b> : 36094	
<b>Estimate Number</b> : 10301	
<b>P.O. Number</b> :	<b>Part Number</b> : D2370
<b>This Issue</b> : 12/4/2007 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2370 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 34932	<b>Material</b> :
<b>Written By</b> : _____	<b>Due Date</b> : 12/11/2007 <b>Qty:</b> <u>6</u> <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est D 01.10.10 Changed D2484 nut for D3015-1 SM est E 06.12.12 ecn 888 ec	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
 		
<b>Comment:</b> PURCHASING Issue p/o: <u>5179</u> <u>CX 7/12/04</u>  Order: Model 12-2A undrilled with grey pad & black belts Supplier: Ferno Aviation Letter of compliance required		
2.0	D2370P	Litter Assembly
 		
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Litter Assembly		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
<b>Comment:</b> PACKAGING RESOURCE #1 Receive and inspect for transit damage Insure that letter of compliance is attached to w/o <u>8/10/21 (6)</u>		
4.0	QC6	DIMENSIONAL CHECK
 		
<b>Comment:</b> DIMENSIONAL CHECK <u>08/10/21 (6)</u>		
5.0	D2374	Stud
 		
<b>Comment:</b> Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Stud Pick: Qty Part Number Description Batch 4 D2374 Stud <u>B31345</u> <u>8/1/21 500</u> 		

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER ASSEMBLY

Job Number: 36094

Part Number: D2370

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2378

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

D2378

Mounting Bolt

B31885 (16)

B36103 (8X)

SP

7.0

D30151

Lock Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Lock Nut

Pick:

Qty

Part Number

Description

Batch

4

D3015-1

Lock Nut

B14710

SP

8.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

4

AN960JD416L

Washer

M106303

SP

9.0

MS27039406

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Batch:

M106541

8/1/21 SP

(6X)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2370

2-Drill 0.191" holes as per Dwg D2370

3-Replace lose rivets with screw per dwg D2370

Apply lockite

M104483

3-Deburr

FF 08-01-22

(6)

POSITIVE  
RECALL

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/4/2007 7:40:48 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER ASSEMBLY

Job Number: 36094

Part Number: D2370

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/22 (6)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

08/01/22 (6)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08.01.22

RECALL  
AUTH  
DATE 08.01.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

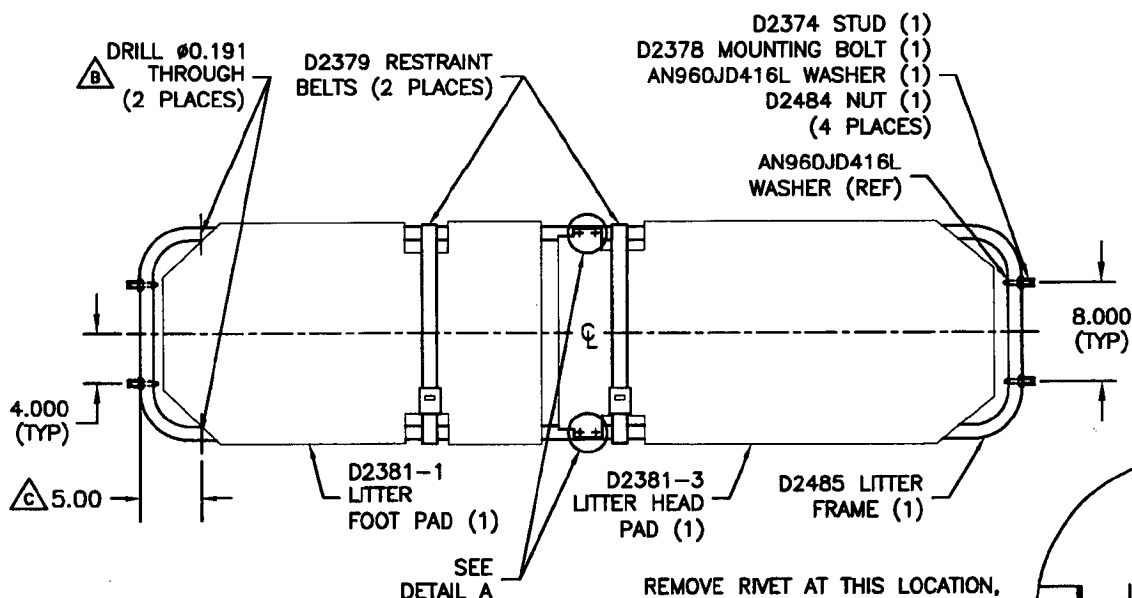
**NOTE:** Date & initial all entries



DESIGN <b>KE</b>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>PH</b>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2370</b>	REV. C SHEET 1 OF 1
DATE <b>06.11.21</b>		TITLE <b>LITTER ASSEMBLY</b>	SCALE NTS
A	95.02.20	NEW ISSUE	
B	98.06.09	ADDED Ø0.191 HOLES	
C	06.11.21	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES, AND 5.00 WAS 5.34	

RELEASED  
06.12.05 *[Signature]*

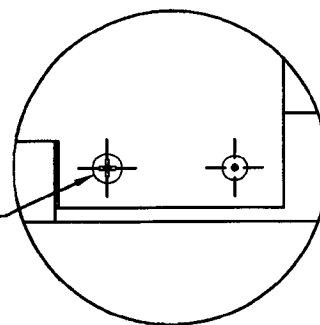
D2370	Part No.	Description
X	D2370	LITTER ASSEMBLY
4	D2374	STUD
4	D2378	MOUNTING BOLT
2	D2379	RESTRAINT BELTS
1	D2381-1	LITTER PAD
1	D2381-3	LITTER PAD
4	D2484	NUT (OR D3015-1) $\triangle$ C
1	D2485	LITTER FRAME
4	AN960JD416L	WASHER
2	MS27039-4-06	SCREW $\triangle$ C



NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE STATED
- 3) FINISH: NONE
- 4) TORQUE SCREWS TO 15-25 in-lb
- 5) REMOVE ALL SHARP EDGES 0.010 TO 0.020 MAX

REMOVE RIVET AT THIS LOCATION, ENLARGE HOLES TO Ø0.213 (#3 DRILL) x 0.75 DEEP, TAP HOLE 1/4-28 UNF x 0.50 DEEP, SECURE PARTS WITH  $\triangle$ C MS27039-4-06 SCREW (1) (2 PLACES)



DETAIL A  
RIVET REPLACEMENT

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W1036094  
C207112/04



70 Weil Way ! Wilmington, OH 45177-9371 ! (937) 382-1451 ! FAX (937) 382-1191

Int'l FAX (937) 382-6569

Visit us at our web site: [www.ferno.com](http://www.ferno.com)

21 January, 2008

### Certificate of Conformance

Manufacturer: Ferno-Washington Inc.

Manufacture Address: 70 Weil Way  
Wilmington, Ohio USA

Order No. C- 830347

P.O. # Ferno Aviation - PO#: 4669  
Dart Aerospace LTD - PO#: ~~5170~~ 5179

Model: 12-2 Stretcher - Gray

Item Number: Ferno-Washington # 0163255  
Dart Aerospace LTD #

Serial Nos. 08 070231, 08 070232, 08 070233, 08 070234, 08 070235, 08 070236

I certify that the above referenced products are produced in accordance with applicable Ferno-Washington Inc. engineering standards using approved manufacturing methods and materials. The products have been inspected using approved test procedures and inspection criteria for Ferno-Washington medical devices.

Ferno-Washington Inc. is a registered manufacturer (Registration No. 1523574) with the United States Food and Drug Administration (FDA) as a manufacturer of medical devices, and the Quality Management System has been verified by the FDA to be in compliance to FDA's Code of Federal Regulations 21 Part 820.

Ferno-Washington, Inc. maintains a Quality Management System that fulfills the requirements of DIN EN ISO 9001:2000, ISO 13485:2003 and CMDCAS (Canadian Medical Devices Conformity Assessment System). Copies of Ferno-Washington, Inc.'s ISO 9001:2000 and ISO 13485 certificates issued by DQS GmbH are available upon request.

Thomas E. Livingston  
Director of Quality